

Work Order ID 101924

May-21-13 3:31:55 PM

\*101924\*

Page 1

Item ID: D3955-7

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Plate

Stop

\*NS2\*

Start Date: 5/21/13

Start Qty: 24.00

\*24\*

Cust Item ID:

Required Date: 6/04/13

Req'd Qty: 24.00

\*24\*

Customer:

Reference:

Approvals:

Process Plan: MLD

Date: 13-05-22 Tooling:

Date:

Run Start

\*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3955	A

100

0.00

\*100\*

Waterjet

0.00

26 0 42 / Jm 13-6-4

FLOW CNC Waterjet

304 .125"

Memo

1-Cut as per Dwg D3955

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

0.00

Quality Control

26 0 42 / Jm 13-6-4

NCR: Yes / No

## **WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: Date:

**QA Closed:**

Work Order: _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
				Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>			
Part No. _____											
NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
Bending		Bend		Grain		Ovalized		Pressure/Forced			
Centre Not Concentric to O/S		BOM/Route		Hardware		Over/Under tolerance		Temperature/Cure			
Cracks		Broken/Damaged		Inspection Incomplete		Part Incorrect		Weld			
Crushed/Crimped		Burrs		Instructions Incomplete/Unclear		Part Lost/Missing		Wrong Stock Pulled			
Cuffs		Contamination		Maintenance		Part Moved					
Heat Treat		Countersink		Mislabeled		Positioned Wrong					
Inspection Strip in Tube		Cut Too Short		Misread		Power Loss/Surge					
Ripples in Bend		Drill Holes		Offset							
Torque Waves in Extrusion		Drawing		Out of Calibration							
Turning Sequence		Finish		Out of Sequence							
Wave/Twist in Tube		Folio		Outside Dimensions							

**Work Order ID** 101924

May-21-13 3:31:55 PM

\*101924\*

Page 2

**Item ID:** D3955-7

Accept

\*N900040100\*

Setup

Start

\*NS1\*

**Revision ID:**

**Item Name:** Plate

Stop

\*NS2\*

**Start Date:** 5/21/13

**Start Qty:** 24.00

\*24\*

Cust Item ID:

**Required Date:** 6/04/13

**Req'd Qty:** 24.00

\*24\*

Customer:

**Reference:**

**Approvals:**

**Process Plan:**

**Date:**

**Tooling:**

**Date:**

Run

Start

\*NR1\*

**QC:**

**Date:**

**SPC (Y/N):**

**Date:**

Stop

\*NR2\*

**Sequence ID/  
Work Center ID**  
120

**Operation  
Description**  
QC8- Inspect parts - second check

**Set Up/  
Run Hours**  
0.00

**Tool ID**

**Tool #**

**Plan  
Code**

**Accept  
Qty**

**Reject  
Qty**

**Reject  
Number**

**Insp.  
Stamp**

\*120\*

QC

Quality Control

**Memo**

0.00  
26  
27  
28  
13 6 4

26

130

Identify as per dwg & Stock Location: STC78

0.00

\*130\*

Packaging

Packaging

**Memo**

0.00

26x

11.10.13-06-6

SP

140

QC21- Final Inspection - Work Order Release

0.00

\*140\*

QC

Quality Control

**Memo**

0.00

13/6/10

13/6/10

MB-061

NCR: Yes / No

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS						
Part No. _____	Rework	Skid-tube	Crosstube	Water Jet	Engineering						
NCR No. _____	Scrap	Machining	Small Fab	Prod. Eng. Coor.	Quality						
	Use-as-is	Thermoforming	Finishing	Rec/Store/Packaging	Other						
	Work Order Update	Large Fab	Composite	Supplier							
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio		<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <hr/> <hr/> <hr/>	
										<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <hr/> <hr/> <hr/>	
										<input type="checkbox"/> Other	

# Picklist Print

May-21-13 3:31:58 PM

Page 1

Work Order ID: 101924

\*101924\*  
\*D3955-7\*

Parent Item: D3955-7

Parent Item Name: Plate

Start Date: 5/21/13

Required Date: 6/04/13

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA  *M304S11GA*		Purchased	No				sf	160.7933	**	8.955789 9.0			

304/316 0.125 Sheet

Location	Loc Qty	Loc Code
MAT020	160.7932632	
122521	19.1432632	
124445	141.65	124445

21/Jun/13 - 6-4.

NCR: Yes / No

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
			Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
	<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain	<input type="checkbox"/> Ovalized	<input type="checkbox"/> Pressure/Forced						
	<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Temperature/Cure						
	<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Weld						
	<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Wrong Stock Pulled						
	<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance	<input type="checkbox"/> Part Moved							
	<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Positioned Wrong							
	<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread	<input type="checkbox"/> Power Loss/Surge							
	<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset	<input type="checkbox"/> Other							
	<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration								
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence									
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions									

DART AEROSPACE LTD	Work Order:	101924
Description: Plate	Part Number:	D3955-7
Inspection Dwg: D3955	Rev: A	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

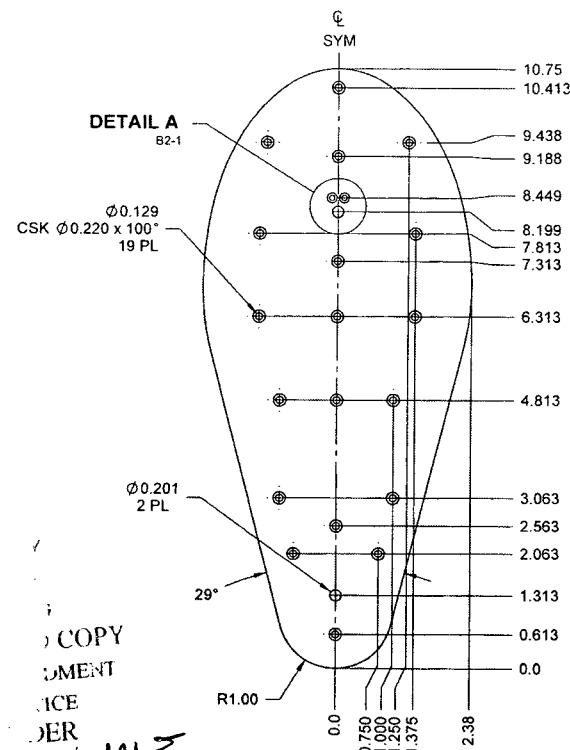
## X First Article      Prototype

DA

Measured by:	<i>Jm</i>	<i>L</i>	Audited by:	<i>27</i> <i>80</i>	Prototype Approval:	N/A
Date:	<i>3-6-4</i>	<i>13-6-9</i>	Date:	<i>13-6-4</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue	KJ	
B	09.11.04	Dimension 0.120 was 0.125	KJ	

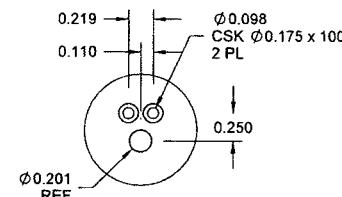
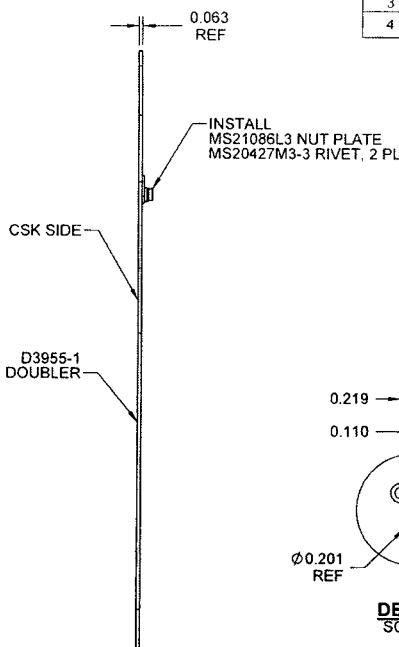
ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3955-041	DOUBLER ASSY
2	1	D3955-1	DOUBLER
3	1	MS21086L3	NUT PLATE
4	2	MS20427M3-3	RIVET



SHOP  
RECEIVED  
ENCL  
UNCONTR<sup>D</sup>  
SUBJECT<sup>D</sup>  
WITH<sup>D</sup>  
W<sup>D</sup>C<sup>D</sup>  
NO. 101924 ML-  
13-05-2

D3955-1 DOUBLER

**D3955-1 NOTES:**  
1) MATERIAL: 6061-T6 ALUMINUM, 0.063 THICK SHEET PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.063)  
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N "D3955-041" USING FINE POINT PERMANENT INK MARKER  
7) WEIGHT: 0.25 lbs

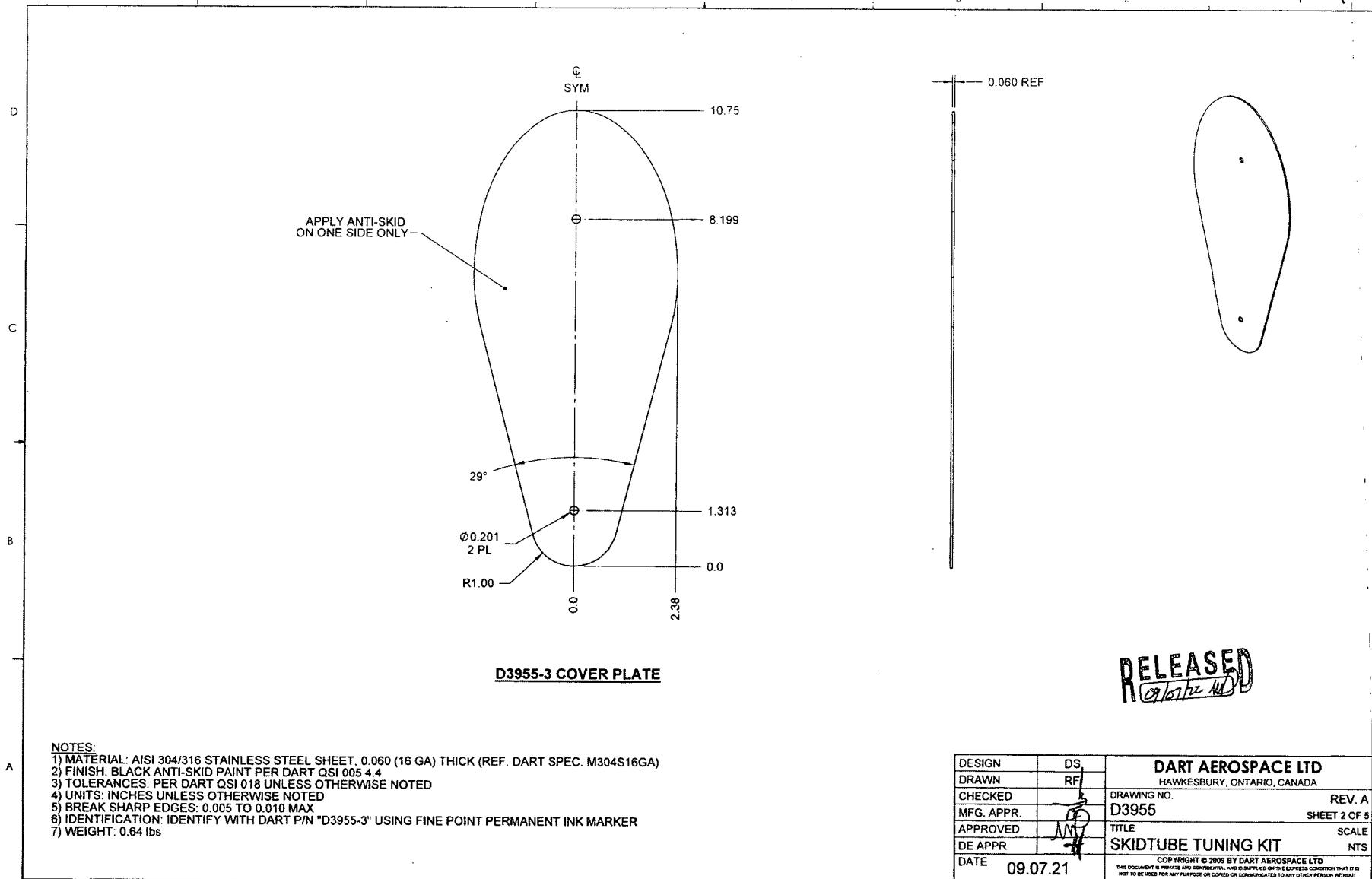


D3955-041 DOUBLER ASSEMBLY

RELEASED  
09/07/22 MWD

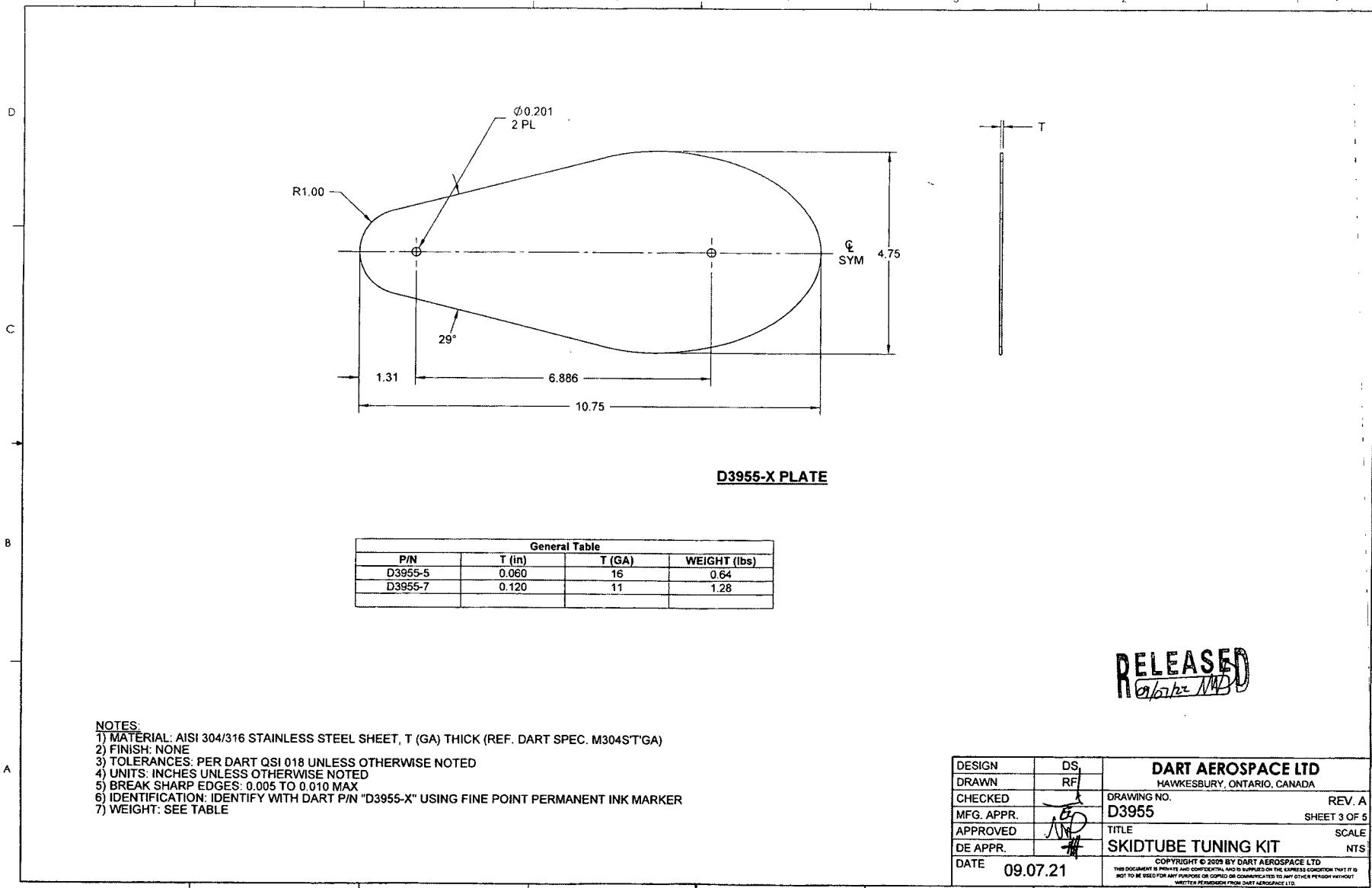
A	NEW ISSUE		RF	09.07.21
REV.	DESCRIPTION		BY	DATE
DESIGN	DS	<b>DART AEROSPACE LTD</b>		
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA		
CHECKED	<u>  </u>	DRAWING NO.	REV. A	
MFG. APPR.	<u>  </u>	D3955	SHEET 1 OF 1	
APPROVED	<u>  </u>	TITLE	SCALE	
DE APPR.	<u>  </u>	SKIDTUBE TUNING KIT	NTS	
DATE	09.07.21	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT		

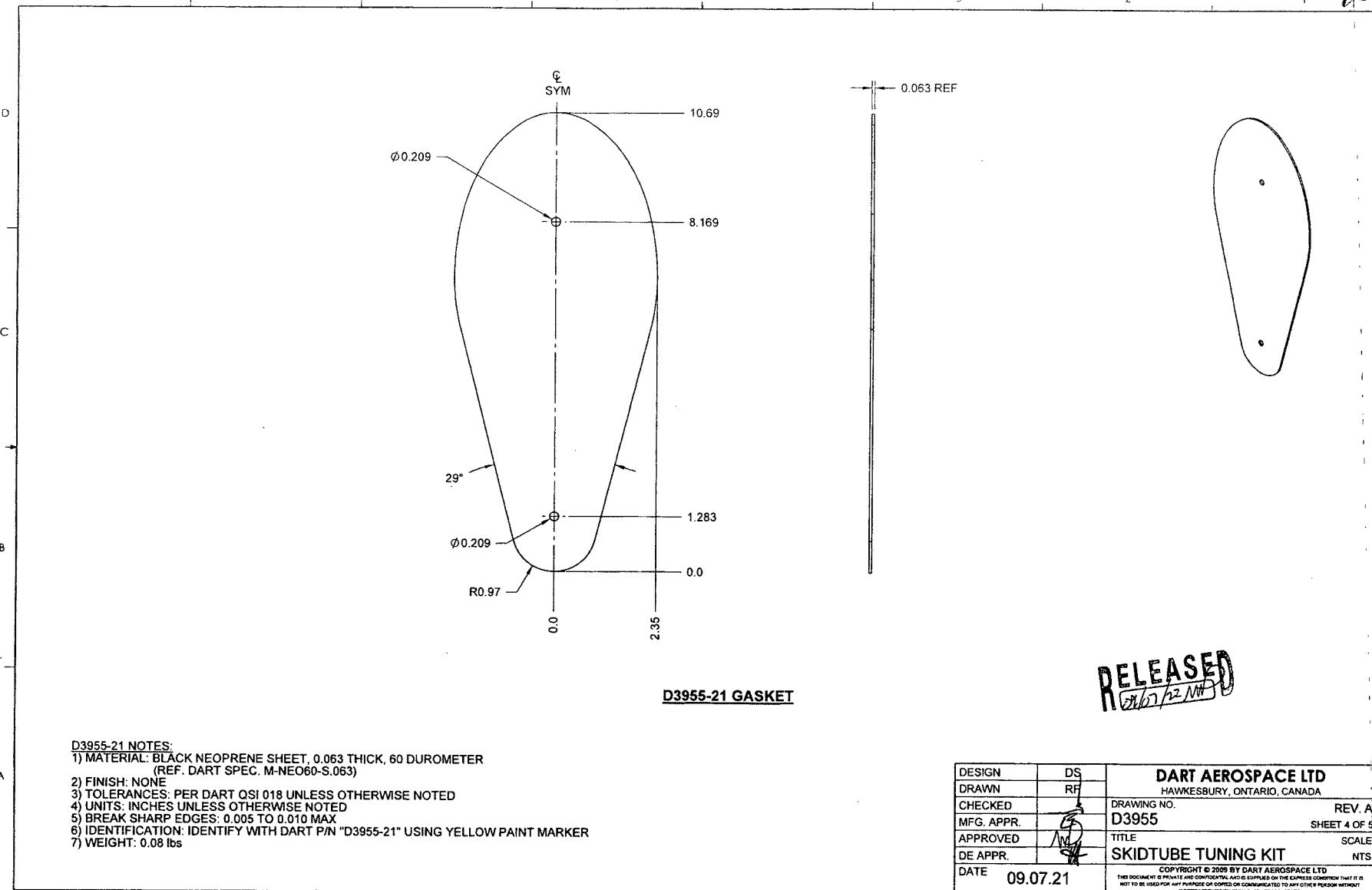
161924



DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		REV. A	
MFG. APPR.		DRAWING NO. D3955	
APPROVED		SHEET 2 OF 5	
DE APPR.		TITLE SKIDTUBE TUNING KIT	
DATE 09.07.21		SCALE NTS	
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101924





**RELEASED**  
2017/12/12

DESIGN	DS	<b>DART AEROSPACE LTD</b>
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED		REV. A
MFG. APPR.		DRAWING NO.
APPROVED		D3955
DE APPR.		SHEET 4 OF 5
DATE	09.07.21	TITLE
		SKIDTUBE TUNING KIT
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101924

